Dart Aerospace Ltd.

Date: Thursday, 9/14/2006 1:02:42 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: BASKET MOD KIT
Job Number	: 28512		
Estimate Number	: 11337		
P.O. Number	: N/A	**Part Number**	: DSI9268011
This Issue	: 9/14/2006 **S.O. No.** : N/A	**Drawing Number**	: D3230 REV A1
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: 9/13/2006 **Type** : LARGE FAB ASSY	**Drawing Revision**	: A1
Previous Run	: 25180	**Material**	: N/A
Written By	:	**Due Date**	: 9/20/2006 **Qty:** 1 **Um:** Each
Checked & Approved By	: 06.09.14		
Comment	: Est Rev:B 08.11.19 Kit redesign KJ/DS		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy bluefile & type labels per PPP DSI 9268-011 CHG002

2.0	M304TS0750W065	304 SQ Tube.75x.75x.065W

Comment: Qty.: 25.8300 f(s)/Unit Total : 25.8300 f(s)
Material: 304/316 SS Tube 0.065" wall
(M304TS0.750W.065)
Batch: M101359 10.3 F(s) / M101561 8 F(s) / M101937 5.83 F(s) 06/09/18

3.0	D23273	Spacer Bushing

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2327-3	Spacer Bushing	B28073

06/09/18

4.0	M304EX07516F	Expanded Metal Flat Stai

Comment: Qty.: 5.2500 sf(s)/Unit Total : 5.2500 sf(s)
Pick:

Qty	Part Number	Description	Batch
5sf	M304EX0.75-16F	Mesh	M101358

06/09/18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector
06.09.18	4	CHANGE 16.00" DIM ON DWG D3230 REV A1 TO 15.75" FOR DRILLING OF Ø0.266 HOLES SEE DS EMAIL				[signature] 06.09.18 per QSI 042	

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes / No (No circled) **DQA:** [signature] **Date:** 06/09/21

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Thursday, 9/14/2006 1:02:43 PM
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Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** BASKET MOD KIT

Job Number: 28512 **Part Number:** DSI9268011

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4 x 3/4 square tubing as per Dwg D3230

2-Fabricate basket wedge assembly as per D3230
A/R SS ROD Batch: M101744

2-Deburr & Remove all Markings From Material

AS 06/08/18

Seq. #:	Machine Or Operation:	Description :
6.0	QC5/9	WELD INSPECTION

Comment: WELD INSPECTION PD 06-09-19 (i)

Seq. #:	Machine Or Operation:	Description :
7.0	POWDER COATING	POWDER COATING

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 FC 06 09 19 (1)

Seq. #:	Machine Or Operation:	Description :
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION a.m 06-09-20 (X)

Seq. #:	Machine Or Operation:	Description :
9.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick Packing Kit

Seq. #:	Machine Or Operation:	Description :
10.0	AN417A	Bolt

Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
5	AN4-17A	Bolt	M101124

Seq. #:	Machine Or Operation:	Description :
11.0	AN960JD416	Washer

Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
5	AN960JD416	Washer	M19165

 Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/14/2006 1:02:43 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: BASKET MOD KIT

Job Number: 28512
Part Number: DSI9268011

Job Number:

Seq. #:	Machine Or Operation:	Description :
12.0	MS21042L4	Nut

Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
5	MS21042L4	Nut (or -4)	M19085

Seq. #:	Machine Or Operation:	Description :
13.0	DSI9053011	BASKET HINGE PLATE CHANGE KIT

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
1	DSI 9053-011	Hinge Change Kit	B26658

P 06/9/21 (1)

Seq. #:	Machine Or Operation:	Description :
14.0	QC4	INSPECT 100% KITS FOR COMPLETENESS

Comment: INSPECT 100% KITS FOR COMPLETENESS C 06/09/21 (1)

Seq. #:	Machine Or Operation:	Description :
15.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP Dsi 9268-011
Location:________
PPP Rev:____A____

P 06/9/21 (1)

Seq. #:	Machine Or Operation:	Description :
16.0	QC21	FINAL INSPECTION/W/O RELEASE

(1)

Comment: FINAL INSPECTION/W/O RELEASE 06/09/21

Job Completion

U 06-09-21

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

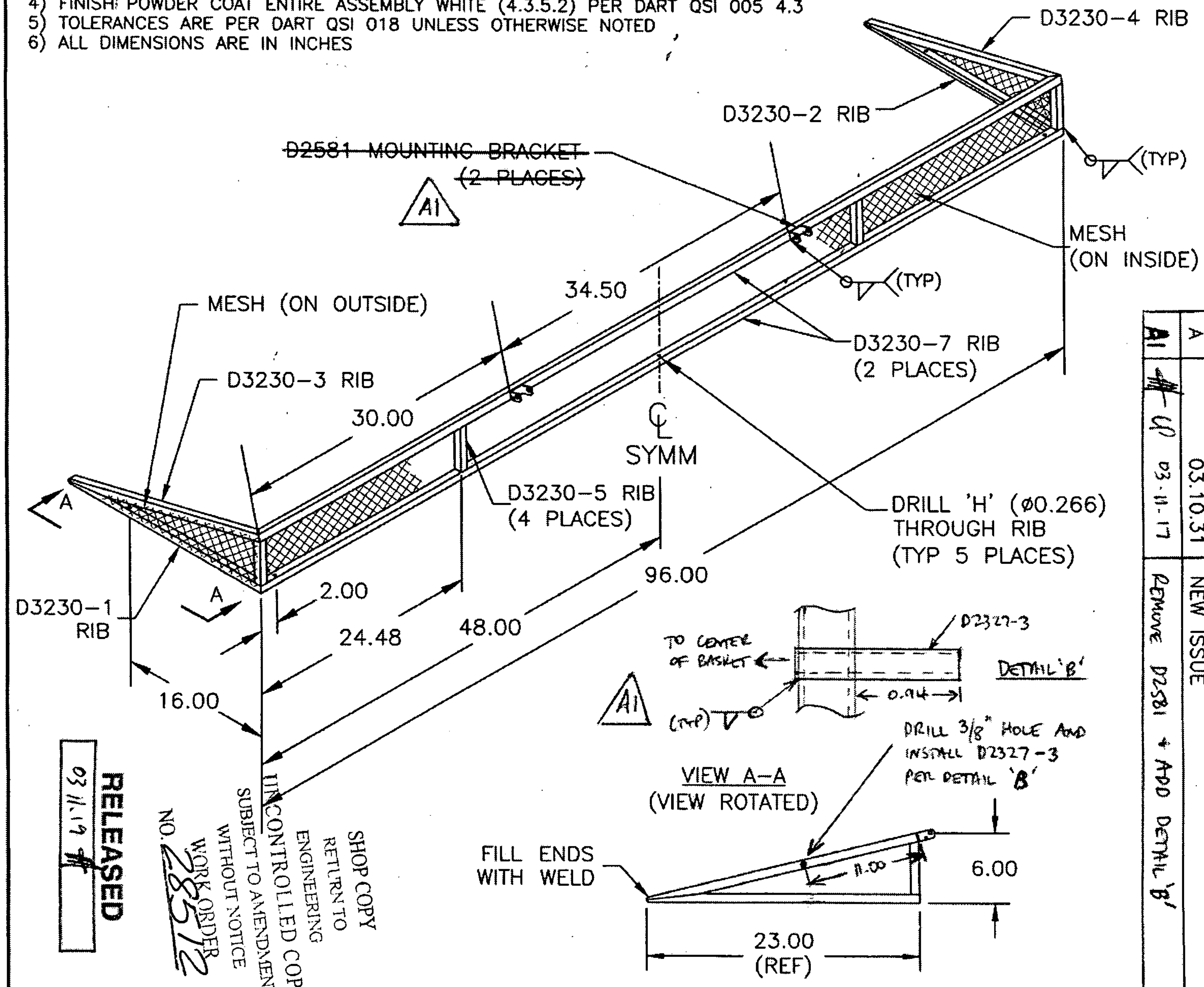
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

D3230-041 BASKET WEDGE ASSEMBLY

1) RIB MATERIAL: AISI 304/316 SS, 3/4x3/4x0.060 WALL SQUARE TUBING (REF DART SPEC. M304TS0.750W.060)
2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC. M304EX0.75-16F)
3) WELD PER DART QSI 004
4) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES



RELEASED 03.11.19

SHOP COPY RETURN TO ENGINEERING

UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER NO. 28512

QA COPY ISSUED

DART

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	DRAWN BY	DRAWING NO.	REV.
CP	CP	D3230	A
CHECKED	APPROVED	TITLE	SHEET 1 OF 2
		BASKET WEDGE ASSEMBLY	SCALE NTS
DATE 03.10.31			

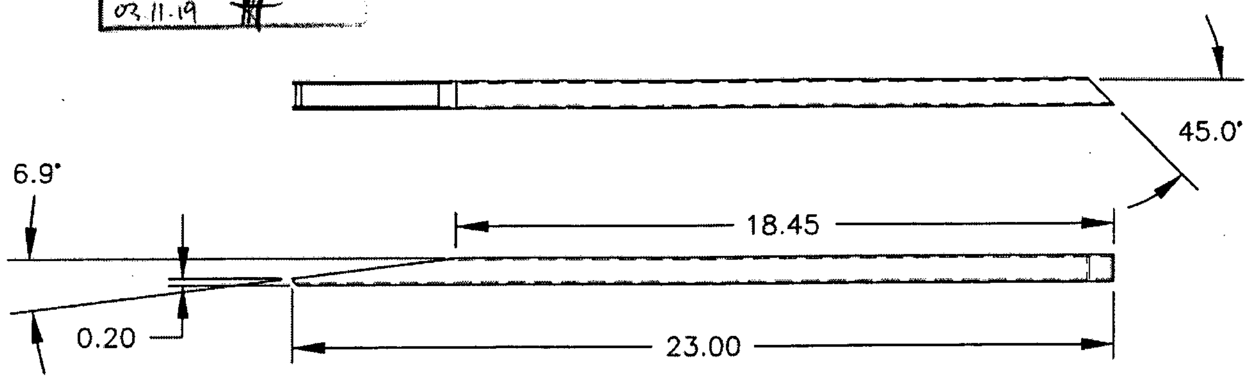
REV	DATE	DESCRIPTION
A	03.10.31	NEW ISSUE
A1	03-11-17	REMOVE D2581 + ADD DETAIL 'B'

DART

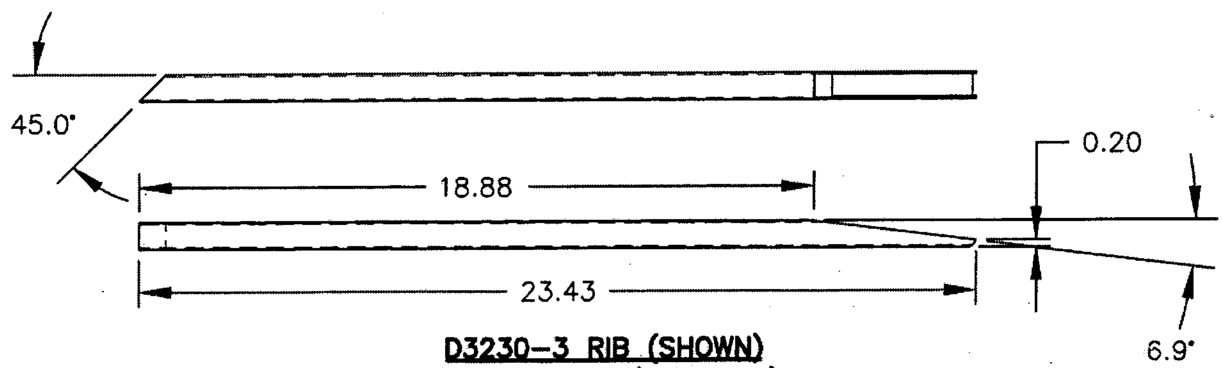
QA COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3230	REV. A SHEET 2 OF 2
DATE 03.10.31		TITLE BASKET WEDGE ASSEMBLY	SCALE 1:5

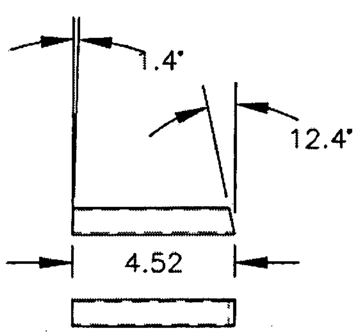
RELEASED 03.11.19



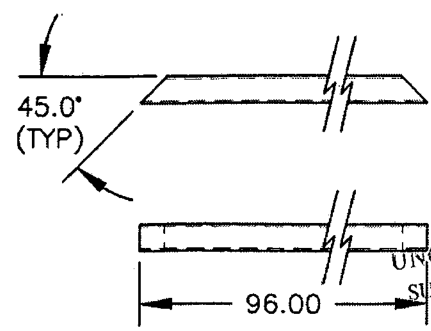
D3230-1 RIB (SHOWN)
D3230-2 RIB (OPPOSITE)



D3230-3 RIB (SHOWN)
D3230-4 RIB (OPPOSITE)



D3230-5 RIB



D3230-7 RIB

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UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 28512

Chris Provencal

From: David Shepherd [davids@dartaero.com]
Sent: December 20, 2005 1:03 PM
To: Chris Provencal
Subject: Re: wedge for 212 basket

15.75" is an acceptable deviation on 16.00".
If it is going to cause a problem in the future, then I agree, you should make this a permanent change by doing an A2 revision to the drawing.

David

----- Original Message -----
From: "Chris Provencal" <cprovencal@dartaero.com>
To: <davids@dartaero.com>
Sent: Tuesday, December 20, 2005 8:43 AM
Subject: wedge for 212 basket

>
> D3230 Rev A1: David D. drilled the 0.266 diam hole at 15.75" instead of
> 16.00". This was because the gap for the nut was too small at 16". At
> 15.75" the gap is just over 0.5" and it needs to be 0.407".
>
> I think this should become a permanent change. When they weld the wedge,
> there can be some variation in the shape and this could happen again and
it
> may not be caught.
>
> Sincerely,
> Chris Provencal
> DART Aerospace Ltd.
> Email..cprovencal@dartaero.com
> Phone...613-632-3336
> Fax.......613-632-4443
>
>